

Date: Wednesday, 3/21/2007 3:49:32 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 31429		
Estimate Number	: 10713		
P.O. Number	: N/A	Part Number	: D3213041
This Issue	: 3/21/2007 S.O. No. : N/A	Drawing Number	: D3213 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 30901	Material	: N/A
Written By	:	Due Date	: 4/4/2007
Checked & Approved By	: <u>07.03.22</u>	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 05-11-17 17:27		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31613	Hinge 15.0"
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
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2	D3161-3	Hinge	<u>B 31034</u> & 6	B 31431 & 14	FF 07-04-10	10
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2.0	D32131	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
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1	D3213-1	Door	<u>B 31702</u>	FF 07-04-10	10
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3.0	D32133	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
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1	D3213-3	Door	<u>B 31433</u>	FF 07-04-10	10
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4.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
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24	MS20470AD4-4	Rivet	<u>M103446</u>	FF 07-04-10	10
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 3:49:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31429

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

FF 07-04-12

10

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/10/12 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m/02316

FF

07/04/17 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 07-04-18

10

9.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2137 Decal

B 31463

FF

07-04-18

10

10.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2419 Handle

B 31424

FF

07-04-18

10

11.0

D2462

Neoprene Seal



Comment: Qty.: 2.4000 f(s)/Unit Total: 24.0000 f(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2462

Seal

B 29456

FF

07-04-18

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 07/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 3:49:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31429

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D27281

Dart Logo label small



(10)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2728-1 Decal B 24215

FF 07-04-18 10

13.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN960JD6 Washer M6085

FF 07-04-18 10

14.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet M102929

FF 07-04-18 10

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3213

FF 07-04-18 10

16.0

QC5

INSPECT WORK TO CURRENT STEP



07-04-18 (10)

Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/04/20 (10)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

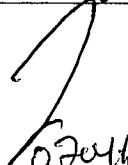
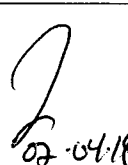
07/04/20

Job Completion



07/04/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-04-18	12.0	Qty 1 sticker. Perman. Change Change already made on the system.				 07-04-18	 07-04-18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

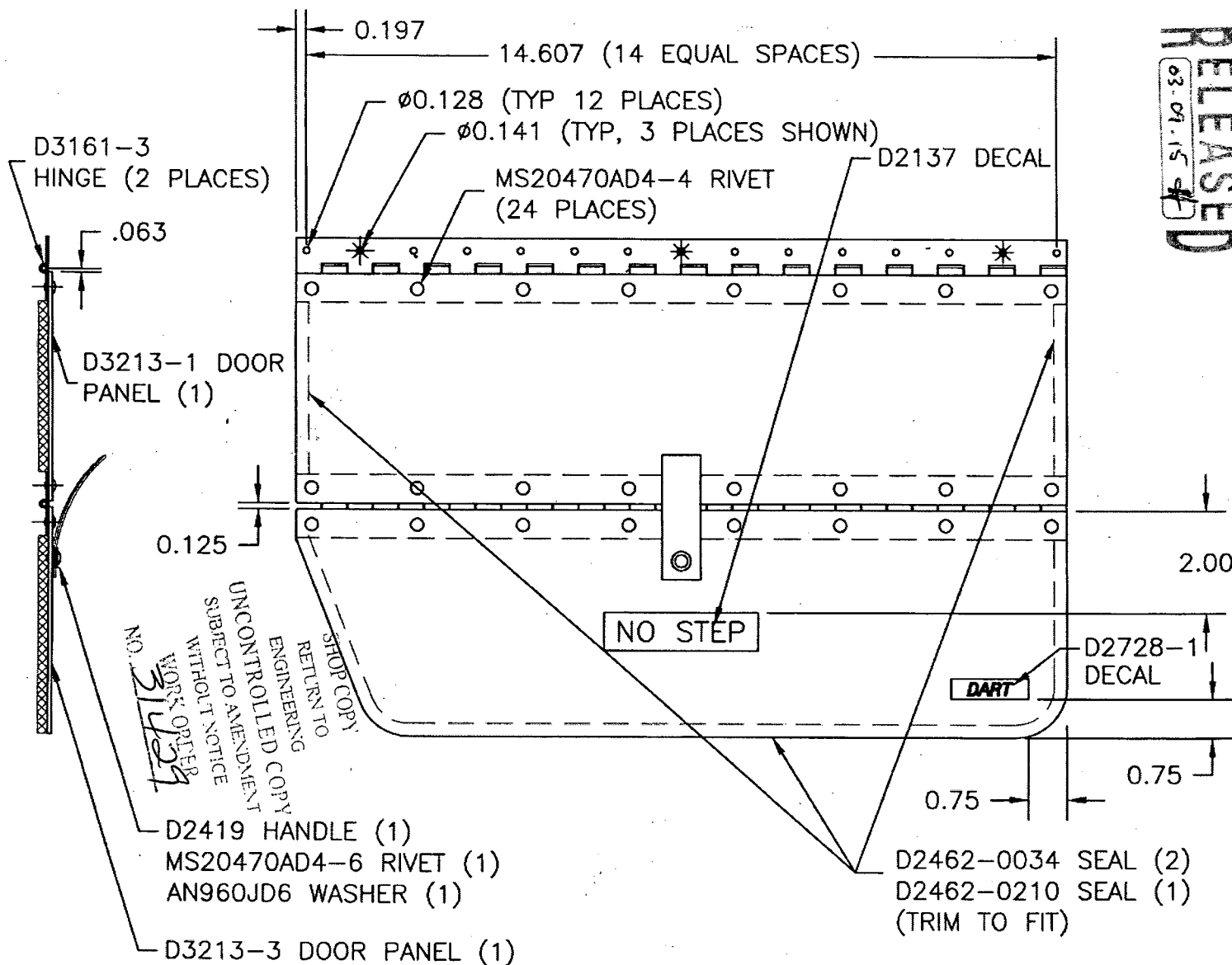
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	✓	APPROVED	✓	HAWKESBURY, ONTARIO, CANADA
DATE	03.09.03	DRAWING NO.	D3213	REV. A
		TITLE	DOOR ASSEMBLY	1 OF 2
			NEW ISSUE	SCALE
				1:3

RELEASED
03.09.15



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

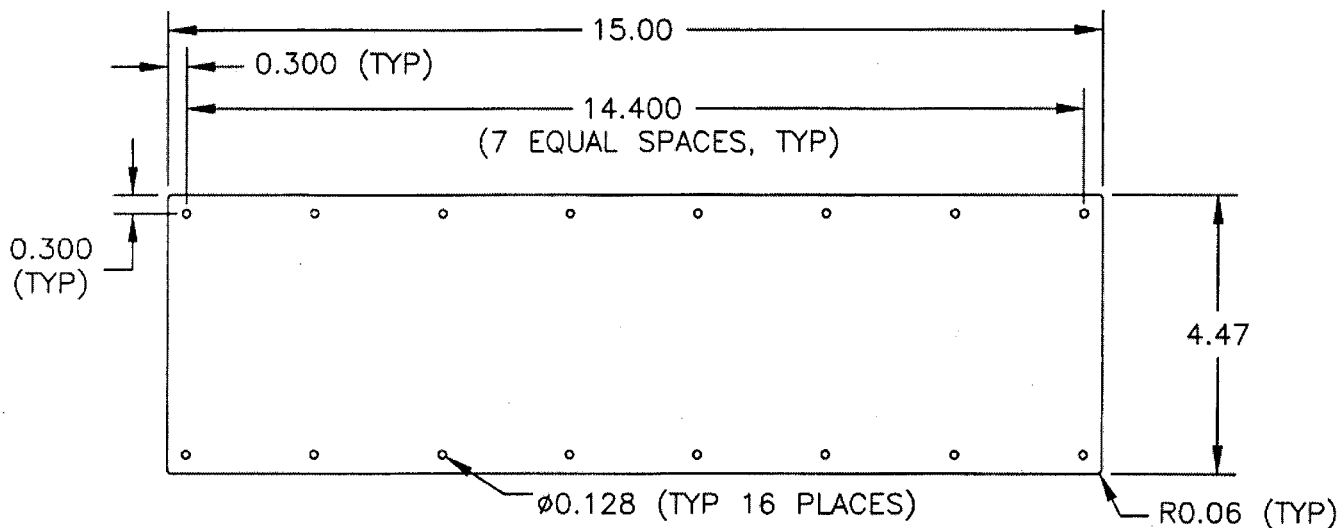
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

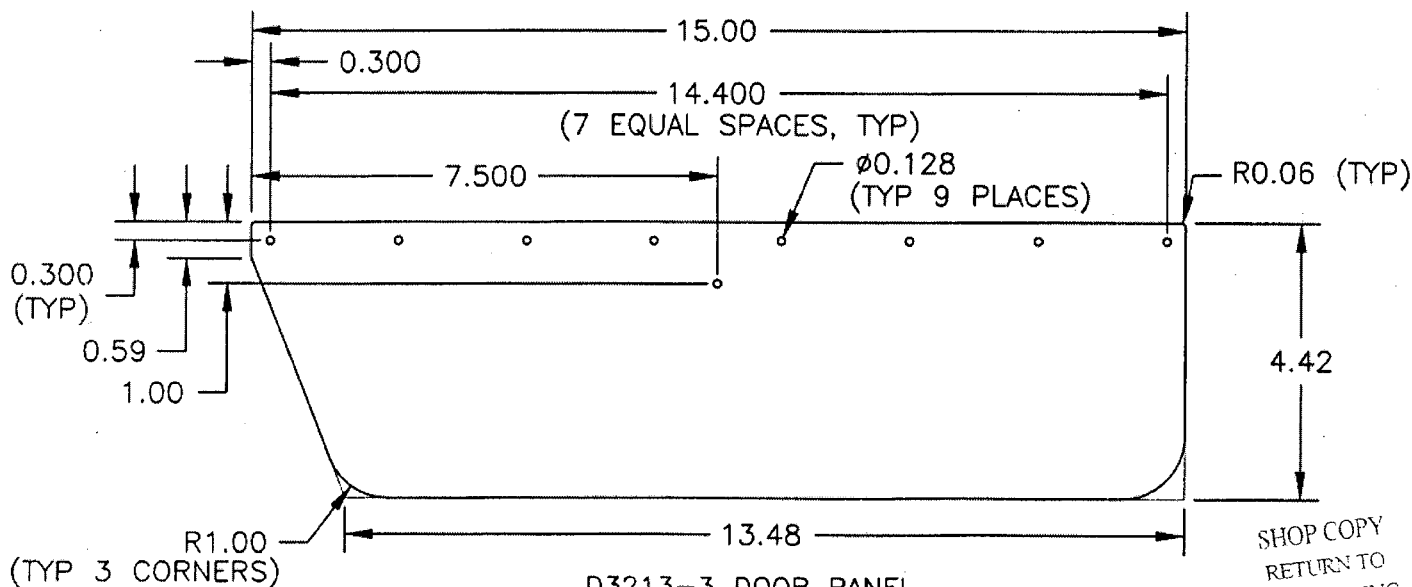
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
UNCONTROLLED COPY
RETURN TO AMENDMENT
WITHOUT NOTICE
03.09.15
NO. 31429

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